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RBE332A94-3400-03-9**Job Sheet 199374****Part No:** RBE332A94-3400-03-9**Job Qty:** 3 pcs

2 MLC

Part Name: Sight Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/21/19**Job Tracking No:****Due Date:** 11/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:****Bill of Materials**

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - 1	3 pcs	11/22/19		0.00	0.60	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	
							Small Fab - 7	
							Small Fab - 8	GP 19-11-25
110	QC 5	3 pcs	11/22/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	NOV 26 2019
							QC 5 - 61	DAS 40 9-89
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	3 pcs	11/22/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	DAS 28 9-89
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
130	QC 21 - FG	3 pcs	11/22/19		0.00	0.00	QC 21 - FG - 21	DAS 21 9-89
							QC 21 - FG - 70	NOV 28 2019
							QC 21 - SA - 53	GA143B

Part Op 100 - Assemble as per DWG. See note 8.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90591A161	Hex Nut M8 x 1.25 65	9 Ea (3 ea)	100-Small Fab - 1	FM138414-7
91166A270	Washer, M8 67	9 Ea (3 ea)	100-Small Fab - 1	203974
91280A550	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG. 70	9 Ea (3 ea)	100-Small Fab - 1	157240
96445K241	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK. 58	36 Ea (12 ea)	100-Small Fab - 1	215208
RBE332A94-3400-03-10 Block	140B	3 pcs (1 ea)	100-Small Fab - 1	213985
140B RBE332A94-3400-03-11 Support	140B	3 pcs (1 ea)	100-Small Fab - 1	165766

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A161	9	60	0
	91166A270	9	179	0
	91280A550	9	19	0
	96445K241	36	12	0
	RBE332A94-3400-03-10	3	3	0
	RBE332A94-3400-03-11	3	3	0

Part Specifications



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not be found.

Plex 8/21/19 8:05 AM Dart.lajeunesse.marie

Container No: S234804



Part: RBE332A94-3400-03-9

Job No: 199374

Serial No/Batch: S234804

Revision: A

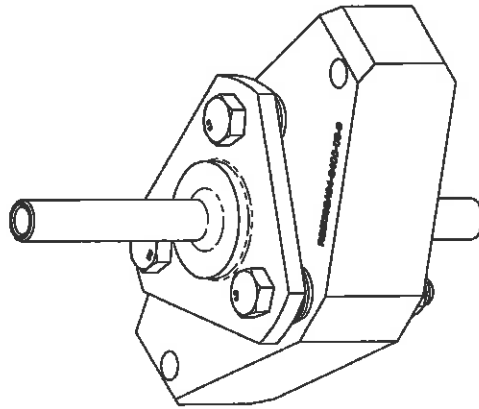
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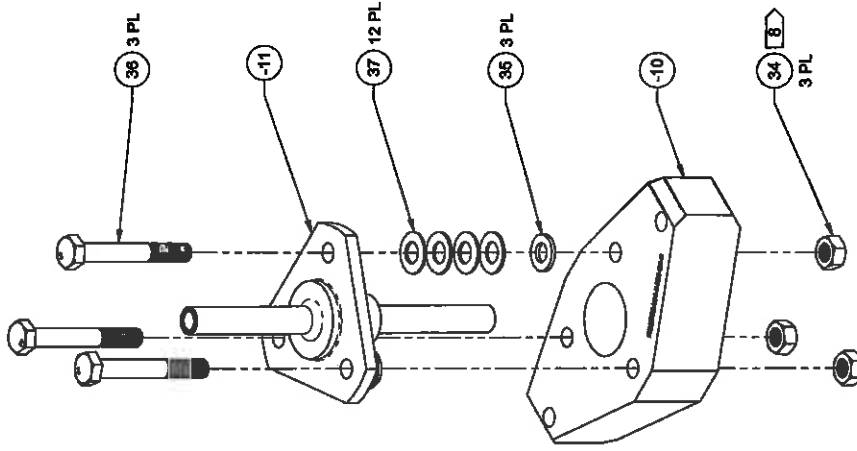
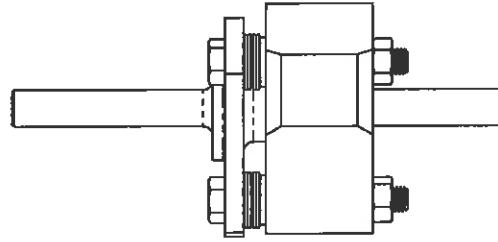
Instructions:

Date: 11/26/19

ITEM #	QTY	PART #	PART TITLE
-10	1	RBE332A94-3400-03-10	BLOCK
-11	1	RBE332A94-3400-03-11	SUPPORT
34	3	McMaster#90591A181 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M8 X 1.25 mm X 6.5 mm HT.
35	3	McMaster#91169A270 OR EQUIV.	ZINC PLATED STEEL WASHER 8.4 mm ID. X 16 mm OD. X 1.4 mm-1.8 mm THK.
36	3	McMaster#91280A550 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.
37	12	McMaster#98445K241 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.



RBE332A94-3400-03-9 SIGHT SUPPORT



NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = ± 0.1 / ± 1
X.XX = ± 0.01 / ± 0.5
X.XXX = ± 0.005 / ± 0.1
X.XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLY AS SHOWN
8) INSTALL ITEM 34 HAND TIGHT
9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
199374
19-08-21

DESIGN DRAWN	KPT	DATE 2/14/2019
CHECKED	KPT	
MFG. APPR.	MBB	
APPROVED	DP	

DART AEROSPACE LTD
HARRISBURG, ONTARIO, CANADA

TOOL PART #
RBE332A94-3400-03

TITLE
T/R DRIVE ALIGNMENT INSPECTION

REV. A
SHEET 10 OF 26
SCALE
NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐
Finishing ☐
Skid-tube ☐
Machining ☐
Large Fab ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____